

Work Order ID 78895

January-17-12 11:46:47 AM

78895

Page 1

Item ID: D3794-3 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket
 Start Date: 17/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3794	Rev A								

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00 B12-2-1
 FLOW CNC Waterjet 1-Cut as per Dwg D3794 Dwg Rev: A Prog Rev: A 2-
 Deburr if necessary (13)

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00 B12-2-1
 Quality Control

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00 8/26/12 X13
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78895

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N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 17/01/2012 **Start Qty:** 12.00 ***12***

Cust Item ID:

Required Date: 31/01/2012 **Req'd Qty:** 12.00 ***12***

Customer:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

Identify as per dwg & Stock Location: 1-P-2

130

0.00

Y13 of Ala/02/02
COUNTED & MEASURED

0.00

140

0.00

Quality Control

112-02-2
(13)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January-17-12 11:46:51 AM

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Work Order ID: 78895

78895

Parent Item: D3794-3

D3794-3

Parent Item Name: Gasket

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased		No		100	sf	682.0000	1.2828	17.104			

MNEO60S 063

NEOPRENE SHEET 0.063

IB12-2-1

Location

Loc Qty

Loc Code

MAT052

682

119130

3

119777

279

119792

400

119792

(13)

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DART AEROSPACE LTD		Work Order: 78895
Description: Gasket		Part Number: D3794-3
Inspection Dwg: D3794	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.190	2		V HB02	
0.300 x 0.300	+/-0.010	.304 x .306	2		V	
1.88	+/-0.030	1.879	2		V	
4.281	+/-0.010	4.289	2		V	
6.44	+/-0.030	6.423	2		V	
6.00	+/-0.030	6.00	2		V	
6.75	+/-0.030	6.75	2		T B01	
2.00	+/-0.030	2.00	2		T	
4.75	+/-0.030	4.75	2		T	
9.50	+/-0.030	9.50	2		T	
14.25	+/-0.030	14.25	2		T	
17.75	+/-0.030	17.75	2		T	
26.74	+/-0.030	26.74	2		T	
29.23	+/-0.030	29.23	2		T	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 12-2-1	Date: 12/2/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DD	
B	08.10.17	17.75 revised per Dwg Rev. A	KJ/DD	

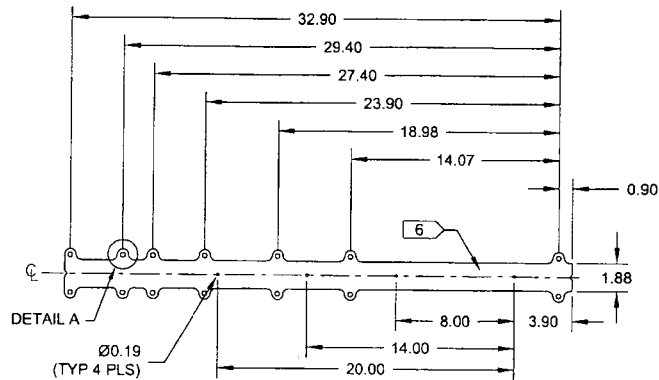
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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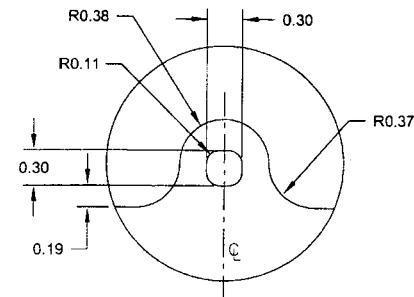
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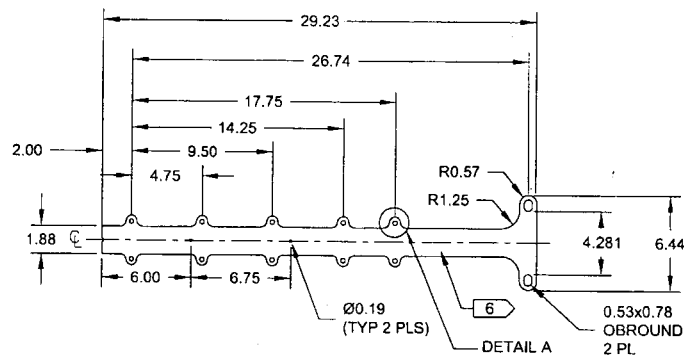
NOTE: Date & initial all entries



D3794-1 GASKET



DETAIL A
SCALE 8X



D3794-3 GASKET

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

WORK ORDER
78895 M.L.J
12/01/17

RELEASED
08-05-14

A		NEW ISSUE		PH	08.05.14
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE USA, INC PORT HADLOCK, WA			
DRAWN					
CHECKED		DRAWING NO.			REV. A
MFG. APPR.		D3794			SHEET 1 OF 1
APPROVED		TITLE			SCALE
DE APPR.		GASKET			NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

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